

Work Order ID 133124

Tuesday, May 26, 2015 12:47:26 PM

133124

Page 1

Item ID: 646.3110 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Channel
Start Date: 6/01/15 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 6/01/15 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: MLJ Date: MAY 27 2015 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
646.3100	N/C								
100		0.00				4	Ø		DAS 40 9-89 15/05/27
100	BAND SAW								
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	Cut Blank at 15.00"								
110		0.03				4	Ø		DAS 37 9-89 15-05-31
110	HAAS CNC VERTICAL MACHINING #1								
HAAS 1	Memo	0.02							
HAAS CNC vertical machine #1	1-Machine per folio FB145 DWG REV: <u>N/C</u> FOLIO REV: <u>AT</u>								
	2- deburr and break all sharp edges								

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																							
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OTHER : _____																																																															

DQA: _____ Date: _____



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				Lead hand / Supervisor Approval Verification	
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Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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OTHER : ☐					

Work Order ID 133124***133124***

Page 4

Item ID: 646.3110

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Channel

Start Date: 6/01/15

Start Qty: 4.00

4

Cust Item ID:

Required Date: 6/01/15

Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

MLS

JUN 25 2015

MC
15-6-24

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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OTHER : ☐					

Picklist Print

Tuesday, May 26, 2015 12:47:26 PM

Page 1

Work Order ID: 133124

133124

Parent Item: 646.3110

646 3110

Parent Item Name: Channel

Start Date: 6/01/15

Required Date: 6/01/15

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A NEW ISSUE 12-10-24 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M7075T6B1.500X1.500		Purchased	No				f	30.7500		6			DAS
M7075T6B1 500X1 500									**			15/05/27	40
7075 T6 BAR 1.500 x 1.500													9-89

Location

Loc Qty

Loc Code

MAT006

30.75

M129891

9

M130312

2

→ M131357

19.75

6.0

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

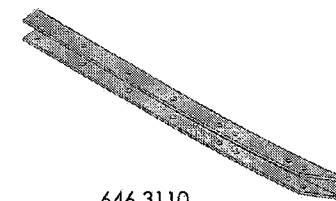
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NOTES:

- 1 MATERIAL: ALUMINUM 7075-T651 AMS-QQ-A-225/9
- 2 FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III CLASS 2, COLOR BLACK; CARDINAL 4860-50 PRETREATMENT PRIMER; PRIME IAW MIL-P-23377J TYPE I CLASS N
3. DEBURR AND BREAK ALL SHARP EDGES
4. IDENTIFY IAW MPP-120

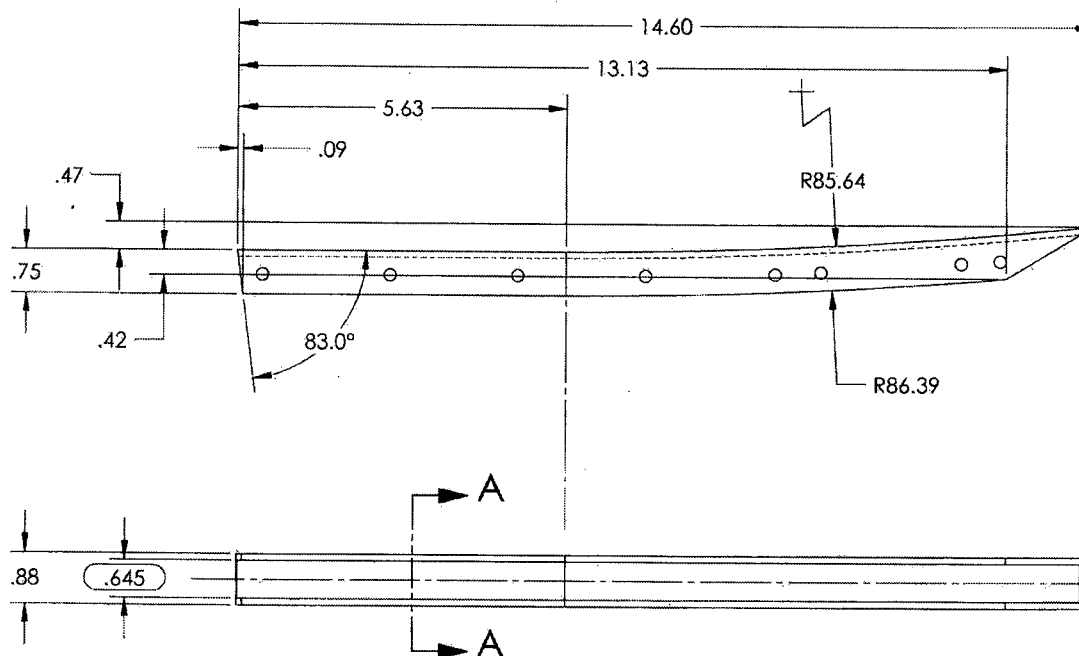
REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED



646.3110

STOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

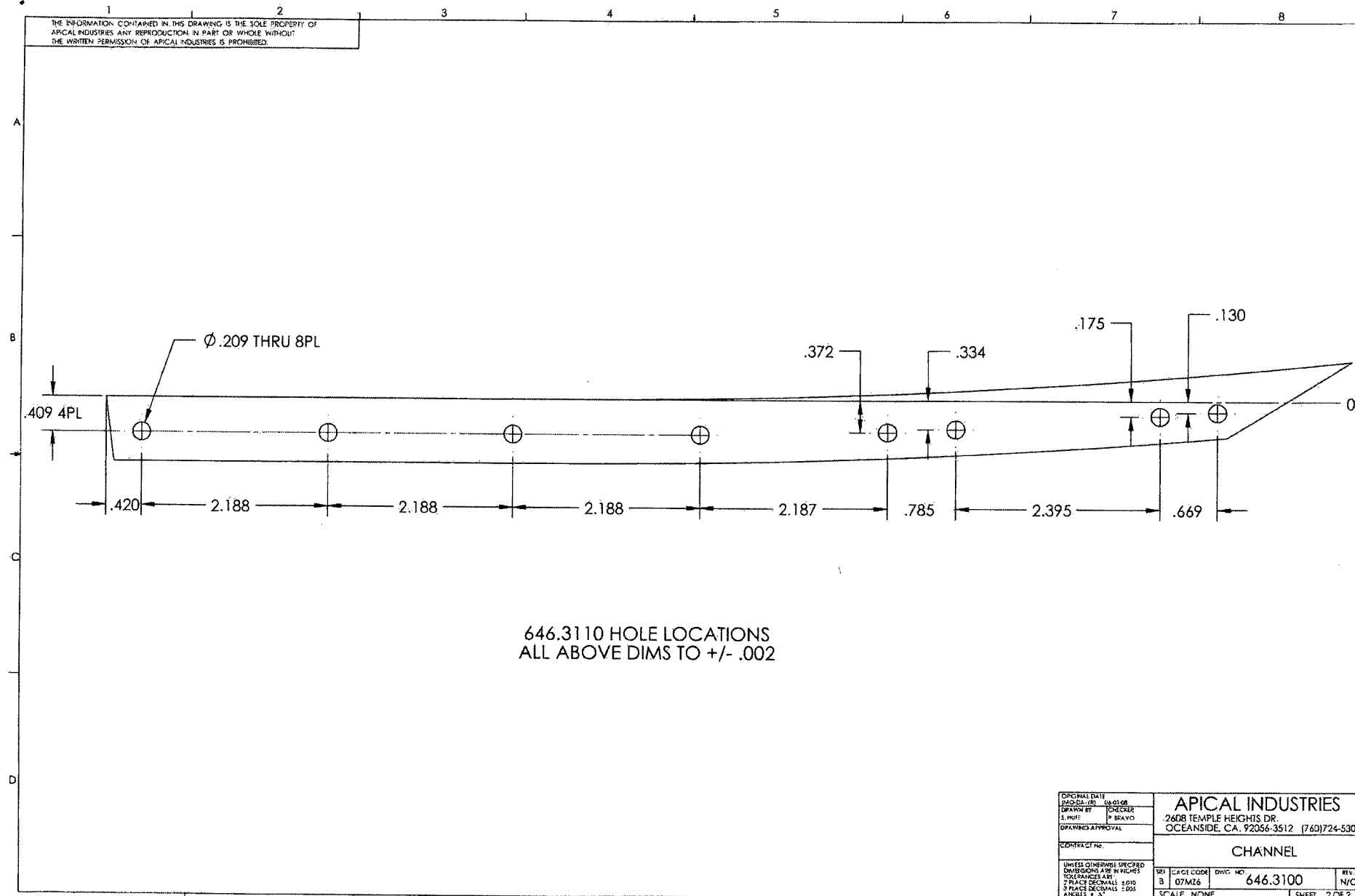
N 133124 ML5
1505-27



SECTION A-A

			646.3110	CHANNEL		
	FIND #	PART #		DESCRIPTION	MAT'L	SPEC.
QTY		PARTS LIST				
NEXT ASSY (S)		APICAL INDUSTRIES				
646.4000		2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300				
DRAWING APPROVAL		CHANNEL				
DESIGNER P. BRAVO		DWG. NO. 646.3100				
CONTRACT NO.		SCALE NONE				
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 3 PLACE DECIMALS ± .010 2 PLACE DECIMALS ± .005 ANGLES ± .5°		REV. N/C				
		SHEET 1 OF 2				

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ORIGINAL DATE		UN-01-08	
DRAWN BY		P. BRAVO	
CHECKED BY		P. BRAVO	
DATE		07/12/08	
CONTRACT NO.		646.3100	
UNLESS OTHERWISE SPECIFIED		TOLERANCES ARE:	
DIMENSIONS ARE IN INCHES		3 PLACE DECIMALS ±.010	
TOLERANCES ARE:		3 PLACE DECIMALS ±.005	
ANGLES ±.5°		SCALE NONE	
APICAL INDUSTRIES		2608 TEMPLE HEIGHTS DR.	
OCEANSIDE, CA. 92056-3512		(760)724-5300	
CHANNEL		SHEET 2 OF 2	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO28784**

Purchase Order Date 6/11/2015

PO Print Date 6/15/2015

Page Number 1 of 3

Order From :

VC-ATG001

Ship To : DART AEROSPACE LTD

A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE ROAD
ROCKLAND, ON K4K 1T2
CANADA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FAXED

Contact Name

Vendor Phone 613-446-4544

Ship To Contact

Ship To Phone

Ship Via: VENDOR'S TRUCK

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax # 10127-2607

Terms

Net 30

Currency

CAD

FOB

FCA - (Free Carrier)

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
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1	133108	D2348 WEARPLATE REV. C	6/19/2015		10.00	\$12.50	\$125.00
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Yes

6/19/2015

BLACK Anodize per MIL-A-8625F Type I or IB or IC or II or IIB Class 2, Type III Class 2

Line Total: \$125.00

2	133124	646.3110 CHANNEL REV. N/C	6/19/2015		4.00	\$25.71	\$102.86
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Yes

6/19/2015

FINISH: HARD BLACK ANODIZE AS PER IAW MIL-A-8625 TYPE III, CLASS 2
PRIME: AS PER IAW MIL-P-23377J TYPE I, CLASS N

Line Total: \$102.86

Note:

6/15/2015



A.T.G. Industries Inc.
731, rue Industrielle Rd.
PLATING DEPARTMENT
Rockland, On K4K 1T2
Canada
Ph: (613) 446-4544
Fax: (613) 446-4556

Pack List

Number: 63771

Date: 18-Jun-15

To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ship To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-5200

Fax: 613-632-1185

Terms		Ship Via	
Quantity	Description		
10 ea	Part: D2348 WEARPLATE ANODIZE AS PER MIL-A-8625 TY II, CLASS 2 Job: 20150462	Rev: C PO: PO28784 Line:	
4 ea	Part: 646.3110 CHANNEL HARD ANODIZE AS PER MIL-A-8625 TY III, CLASS 2 PRIME AS PER MIL-P-23377J TYPE I CLASS N PRIMER IS SUPPLY BY THE CUSTOMER Job: 20150463	Rev: PO: PO28784 Line:	SP15-06-22
6 ea	Part: 646.3716 GAUGE BRACKET HARD ANODIZE AS PER MIL-A-8625 TY III, CLASS 2 PRIME AS PER MIL-P-23377J TYPE I CLASS N PRIMER IS SUPPLY BY THE CUSTOMER Job: 20150464	Rev: A PO: PO28784 Line:	
4 ea	Part: 647.7820 CROSS BAR HARD ANODIZE BLACK MIL-A-8625 TYPE III CLASS 2 PRIME MIL-P-23377J TYPE I CLASS N PAINT IS SUPPLIED BY CUSTOMER Job: 20150465	Rev: PO: PO28784 Line:	
Certificate of Conformance A.T.G. Industries certifies that all items in this shipment are in conformance with all requirements, specifications and drawings referenced in the purchase order. ISO 9001 : 2008 REGISTERED ATG SALES-2010 TERMS APPLY DATE : 18/6/15			

A.T.G. Industries Inc.
731, rue Industrielle Rd.
PLATING DEPARTMENT
Rockland, On K4K 1T2
Canada
Ph: (613) 446-4544
Fax: (613) 446-4556

Pack List

Number: 63771

Date: 18-Jun-15

To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ship To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-5200

Fax: 613-632-1185

Terms		Ship Via
Quantity	Description	
	CERTIFIED SIGNATURE : <u></u>	
	RECEIVER SIGNATURE : <u>SP 15-06-22</u>	